

Date: Tuesday, 4/18/2006 10:02:16 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 26667		
Estimate Number	: 10373		
P.O. Number	: N/A	Part Number	: D30641
This Issue	: 4/18/2006 S.O. No. : N/A	Drawing Number	: D3064 REV. A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 23406	Material	: N/A
Written By	: <u>SER 1A COMMENT Below</u>	Due Date	: 5/20/2006
Checked & Approved By	: <u>06/04/06</u>	Qty:	160 Um: Each
Comment	: Est:B 02/04 Re-format KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 11.4744 f(s)

Lug Extrusion

(D2423)

Batch: B23779J.G/K06/04/06 30

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut D2423 Extrusion: 0.82" Long

J.G/K06/04/06 30

3.0	HAAS1 PG	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Check for cracks while loading into the machine

Machine as per Folio FA176 and Dwg D3064

Tumble and Deburr

Identify as D3064-1

machine per drawing D3064 Rev. A

material supplied by Dart D2423 B23779

issue P.O to Metec 0206105101 P/O: 1134

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect for transit damage06/05/24 160

5.0	QC2	SECOND CHECK
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Comment: SECOND CHECK

Inspect

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 30/06/01

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:02:16 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 26667

Part Number: D30641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H-M 06/05/25

160

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/29

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/05/31

100

SL 06/05/30

30

100

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5121

SL 06/05/31

160

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/01

Job Completion



06/06/01

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	26667
<b>Description:</b> Clamp		<b>Part Number:</b>	D3064-1
<b>Inspection Dwg:</b> D3064 <b>Rev:</b> A1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.306	+/-0.010					
2.222	+/-0.010					
0.375	+/-0.010					
0.735	+/-0.010					
0.250	+/-0.010					
0.345	+/-0.010					
R0.375	+/-0.010					
Ø0.257	+0.005/-0.000					
0.750	+/-0.010					
R0.032	+/-0.010					
R0.338	+/-0.010					
0.375	+/-0.010					
0.375	+/-0.010					
3.450	+/-0.010					
4.200	+/-0.010					
R1.200	+/-0.010					

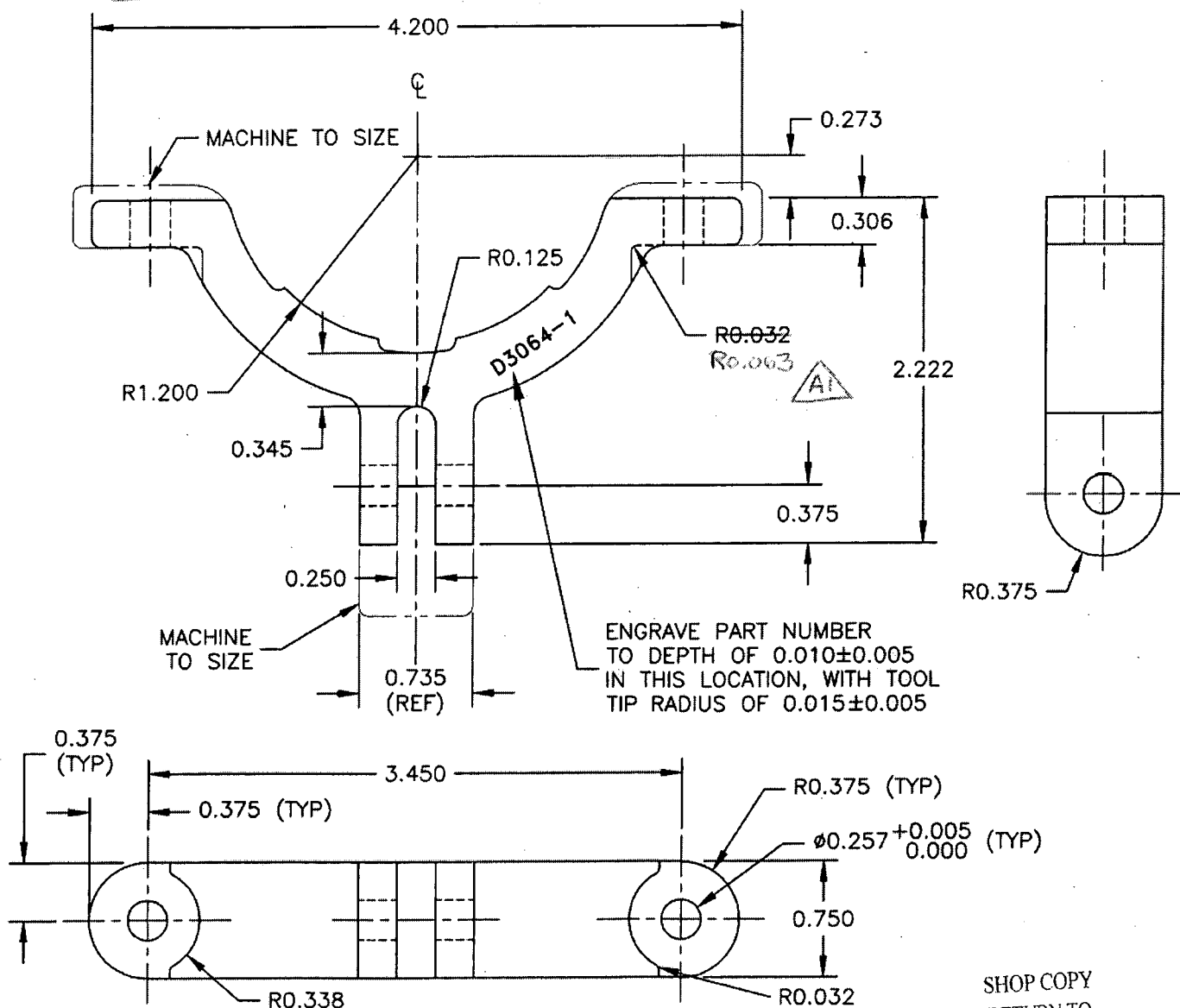
<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3064	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE CLAMP	SCALE 1:1
A	02.09.11	NEW ISSUE	
AI	<i>CP</i> 03.04.29	0.063 WAS 0.032	

RELEASED  
02.04.20



D3064-1 CLAMP

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.005-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26667

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

160

D3064-1 ✓


Clamp

1134

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi (Regula) Walz

Vankleek Hill, May 17, 2006

